

Ship 20/08

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:06:24 PM  
User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GROUND PLATE
Job Number	: 41023		
Estimate Number	: 13282		
P.O. Number	:	Part Number	: D37971
This Issue	: 06/08/2008 S.O. No. :	Drawing Number	: D3797 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 40688	Material	:
Written By	:	Due Date	: 28/08/2008
Checked & Approved By	: <u>JUD 08-08-06</u>	Qty:	57 1/2 Um: Each
Comment	: Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S050	6061-T6 .050 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.9595 sf(s)  
6061T6 aluminium sheet .050" thick  
(M6061T6S050)  
Batch: 104186 HB 8-8-7

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
1-Cut as per Dwg D3797  
Dwg Rev: A  
Prog Rev: A

HB 8-8-7

(7)

2- Deburr if necessary

HB 8-8-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 2/8/8 (x2)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

ST/20

C 8/8 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:06:24 PM

User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GROUND PLATE

Job Number: 41023

Part Number: D37971

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

Des 08/08/08

Job Completion



MF 08-08-08

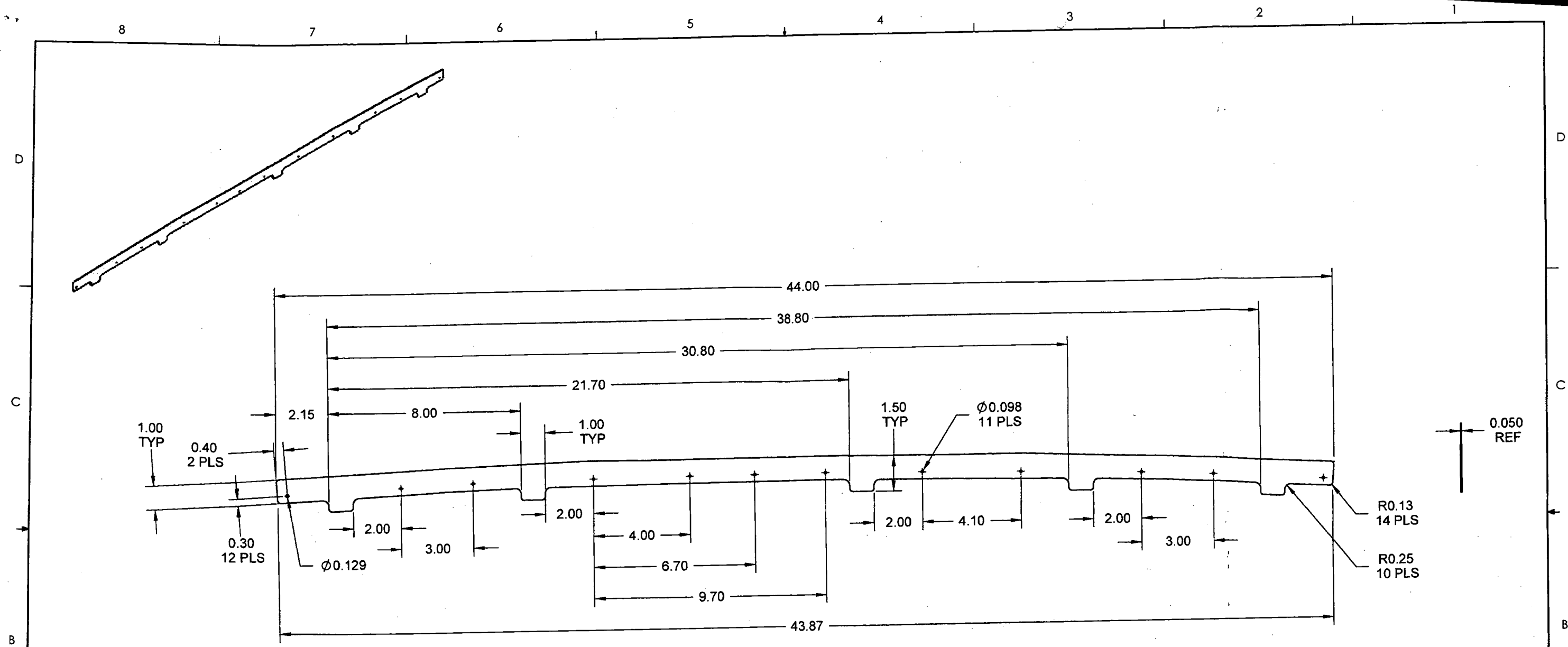
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D3797-1 GROUND PLATE**

**NOTES:**

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM SHEET 0.050 THICK (REF. DART SPEC. M5052H32S.050 OR M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs

A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	N/A	D3797	SHEET 1 OF 1
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	GROUND PLATE	NTS
DATE	08.05.26	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 41023

DART AEROSPACE LTD		Work Order: 41023
Description: GROUND PLATE		Part Number: D3797-1
Inspection Dwg: D3797-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	*			
1.00	+/- .030	1.003	✓			
.30	+/- .030	.302	✓			
2.00	+/- .030	2.004	*			
3.00	+/- .030	3.003	✓			
2.00	+/- .030	2.00	✓			
4.00	+/- .030	4.001	✓			
6.70	+/- .030	6.695	✓			
9.70	+/- .030	9.70	✓			
2.00	+/- .030	2.00	✓			
4.10	+/- .030	4.097	✓			
2.00	+/- .030	2.00	✓			
3.00	+/- .030	3.004	✓			
43.87	+/- .030	43.87	✓			
2.15	+/- .030	2.15	✓			
8.00	+/- .030	8.00	✓			
21.70	+/- .030	21.70	✓			
30.80	+/- .030	30.80	✓			
38.80	+/- .030	38.80	✓			
44.00	+/- .030	43.91	✓			
1.50	+/- .030	1.504	✓			

Measured by: JB	Audited by: S	Prototype Approval: u
Date: 8-8-7	Date: 8/8/4	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	